

Date: Monday, 09/02/2009 4:31:06 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BLADE POSITIONER	
<b>Job Number</b> :	45652	<b>Part Number</b> :	PB674300127	
<b>Estimate Number</b> :	13530	<b>Drawing Number</b> :	B6743001 P.4	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	09/02/2009	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	B1	
<b>First Issue</b> :	//	<b>Material</b> :		
<b>Previous Run</b> :	45651	<b>Due Date</b> :	15/04/2009	<b>Qty:</b> 2 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	<u>MF 09-03-05</u>			
<b>Comment</b> :	Est Rev:A 08-07-29 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300135	PB67-43001-35 Lower Pad Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 PB67-43001-35 Lower Pad Assembly  
 batch: B 45030

MF 09-03-23

2.0	PB674300131	PB67-43001-31 Upper Restraint Weldment
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 PB67-43001-31 Upper Restraint Weldment  
 batch: B 4200 40064

MF 09-03-23

3.0	PB674300129	PB67-43001-29 Blade Positioner Weldment
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 PB67-43001-29 Blade Positioner Weldment  
 batch: B 45032

MF 09-03-23

4.0	PB6743001285	PB67-43001-285 Upper Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 PB67-43001-285 Upper Tube  
 batch: 40245 x1, 44974 x1

lpl 09-04-09

5.0	PB674300119	PB67-43001-19 Inner Tube and Retainer Bu
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 PB67-43001-19 Inner Tube and Retainer Bu  
 batch: 40240, 41369

lpl 09-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45652

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001293

Extension Tube Adjustmnt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Extension Tube Adjustmnt

batch: ~~41862~~ 41862

MF 09-03-23

7.0

PB6743001289

Handle Adjustmnt Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Adjustmnt Fitting

batch: ~~B 40060~~ 418 B46246

CP 09-04-09

8.0

PB6743001291

Clamp Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp Bushing

B 40060

MF 09-03-23

9.0

AN622A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m110155

MF 09-03-23

10.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch: m110139

MF 09-03-23

11.0

NAS1149F0632P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m18057

MF 09-03-23

12.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m18986

MF 09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Drawing Name: BLADE POSITIONER

Job Number: 45652

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21042L6

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M 108187

mf 09-03-23

14.0

MS27039109

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

batch: M107378

mf 09-03-23

15.0

NAS1149F0316P

WASHER



Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

WASHER

batch: 11/124

P/L 09.04.09

16.0

MS27039104

Inventory



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Inventory

batch: m18431.

mf 09-03-23

17.0

MS24694S102

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: \_\_\_\_\_

mf. 09-04-09

18.0

AN526A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: \_\_\_\_\_

19.0

NAS1149F0532P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: BLADE POSITIONER

Job Number: 45652

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Nut  
batch: \_\_\_\_\_

21.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
WASHER  
batch: \_\_\_\_\_

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- slide -289 , -291 and -293 on -19 tube then slide it in -285 tube  
2- drill holes 0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg  
3- assemble all parts as per dwg PB67-43001

PPL 09-04-09 (X2)  
B 09-04-08 (X2)

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/09 (X2)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

P 045657

88 09/04/13 (X2)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/13 (X2)

Job Completion



- MUF  
09-04-13

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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